

Date: Tuesday, 27/05/2008 2:47:21 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PANEL	
<b>Job Number</b> : 39519		
<b>Estimate Number</b> : 10769		
<b>P.O. Number</b> :	<b>Part Number</b> : D3330 <sup>1-2</sup>	
<b>This Issue</b> : 27/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3330 REV D	
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A	
<b>First Issue</b> : // <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D	
<b>Previous Run</b> : 37440	<b>Material</b> :	
<b>Written By</b> :	<b>Due Date</b> : 10/06/2008	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08-5-27</u>		
<b>Comment</b> : Est: A 05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM est C 07.05.14 rev c dwg ec EST D 07.12.12 revD dwg EC verified by:DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M1010S125	1010-1025 sheet .125
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**Comment:** Qty.: 1.1445 sf(s)/Unit Total : 9.1560 sf(s)

1010-1025 sheet .125

Batch: 107513 IB 8-5-28

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET

1-Cut as per Dwg D3330

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

IB 8-5-28

IB 8-5-28

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-5-28

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

S 08/05/28 (24)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE

Form as per Dwg D3330

S 8/11/17 (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 27/05/2008 2:47:21 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 39519

Part Number: D33301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/6/17 (74)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 488

8/11/17

CR TOOK 1 PIECE SC

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18 (8)

Job Completion



MF 08-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39519
<b>Description:</b> Panel		<b>Part Number:</b> D3330-1
<b>Inspection Dwg:</b> D3330	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.327	+0.006/-0.001	0.328	*			
16.66	+/-0.030	16.66	*			
1.69	+/-0.030	1.695	*			
4.646	+/-0.010	4.643	*			
0.750	+/-0.010	0.757	*			
6.77	+/-0.030	6.774	*			
10.41	+/-0.030	10.41	*			
6.45	+/-0.030	6.35	*			
6.000	+/-0.010	5.999	*			
2.000 Pitch	+/-0.010	2.000	*			
2.323	+/-0.010	2.320	*			
0.80	+/-0.030	0.793	*			

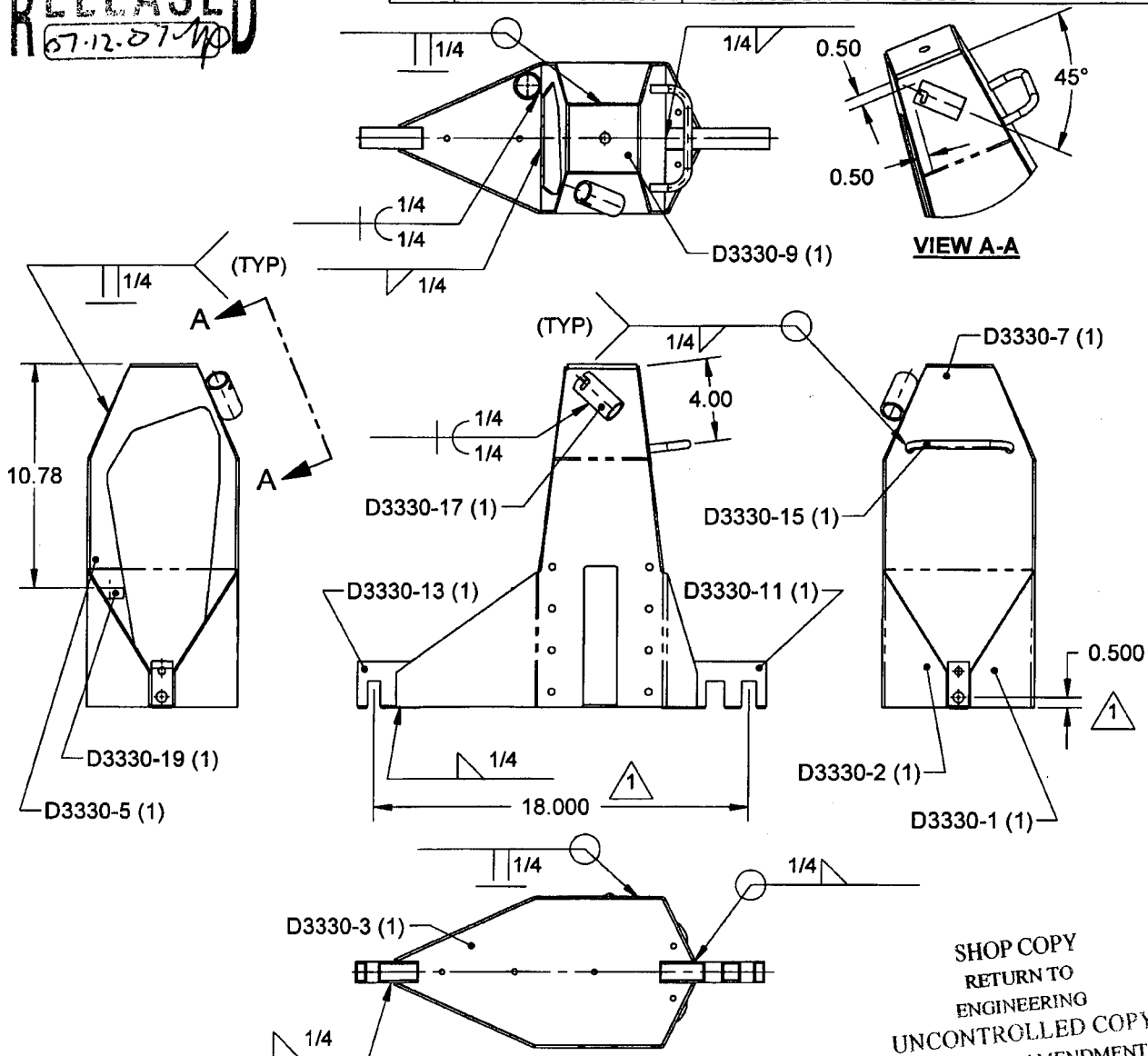
<b>Measured by:</b> B	<b>Audited by:</b> f	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-5-21	<b>Date:</b> 08/05/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	
B	07.05.16	Dwg Rev updated	KJ/EC	B



RELEASED  
07-12-07

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CHECKED <i>JS</i>	APPROVED <i>WFP</i>	DRAWING NO. <b>D3330</b>	REV. D SHEET 1 OF 9
DATE <b>07.12.06</b>		TITLE <b>FRAME WELDMENT</b>	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	



### D3330-041 FRAME WELDMENT

#### NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

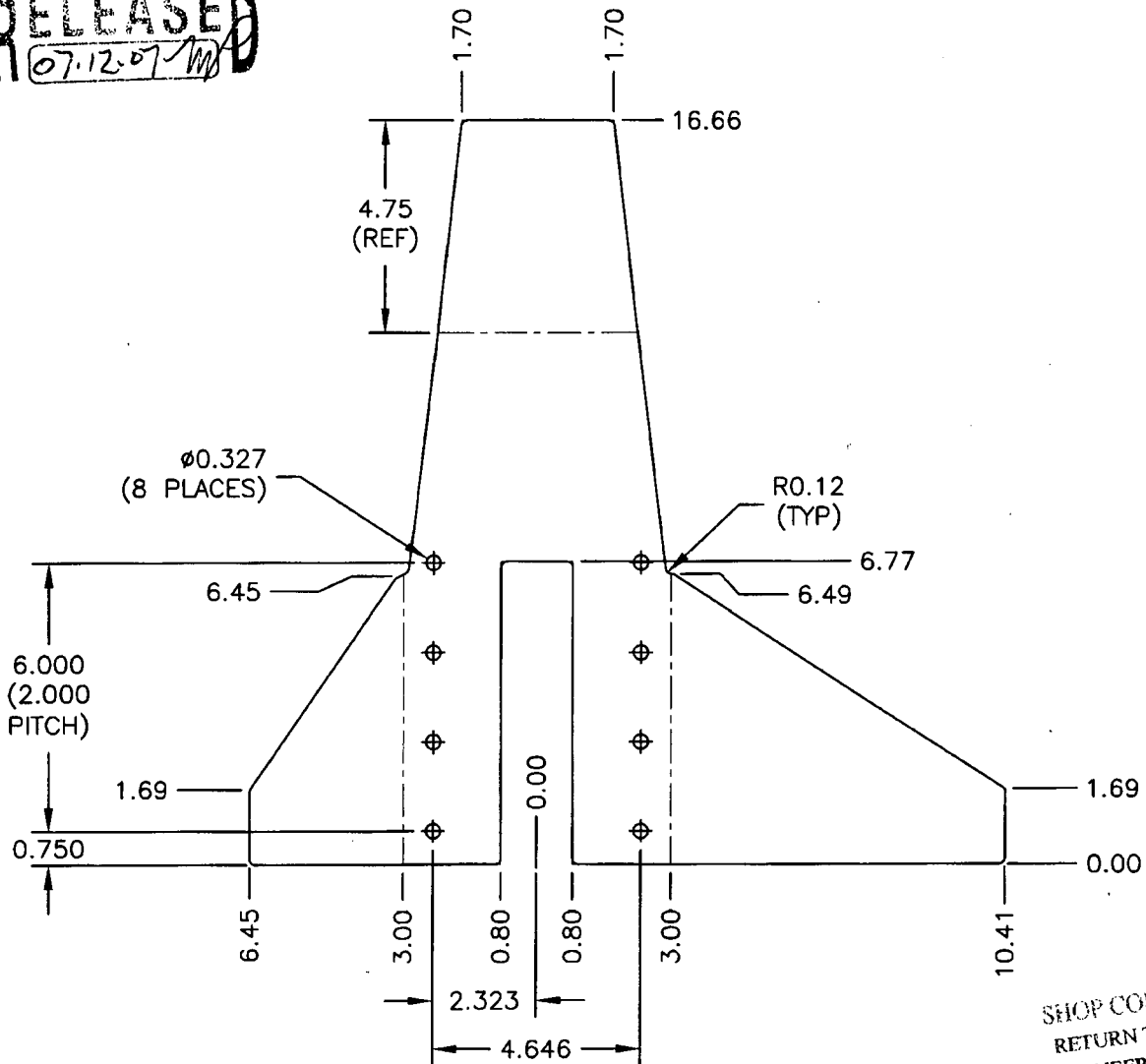
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

**RELEASED**  
07.12.07 *[Signature]***D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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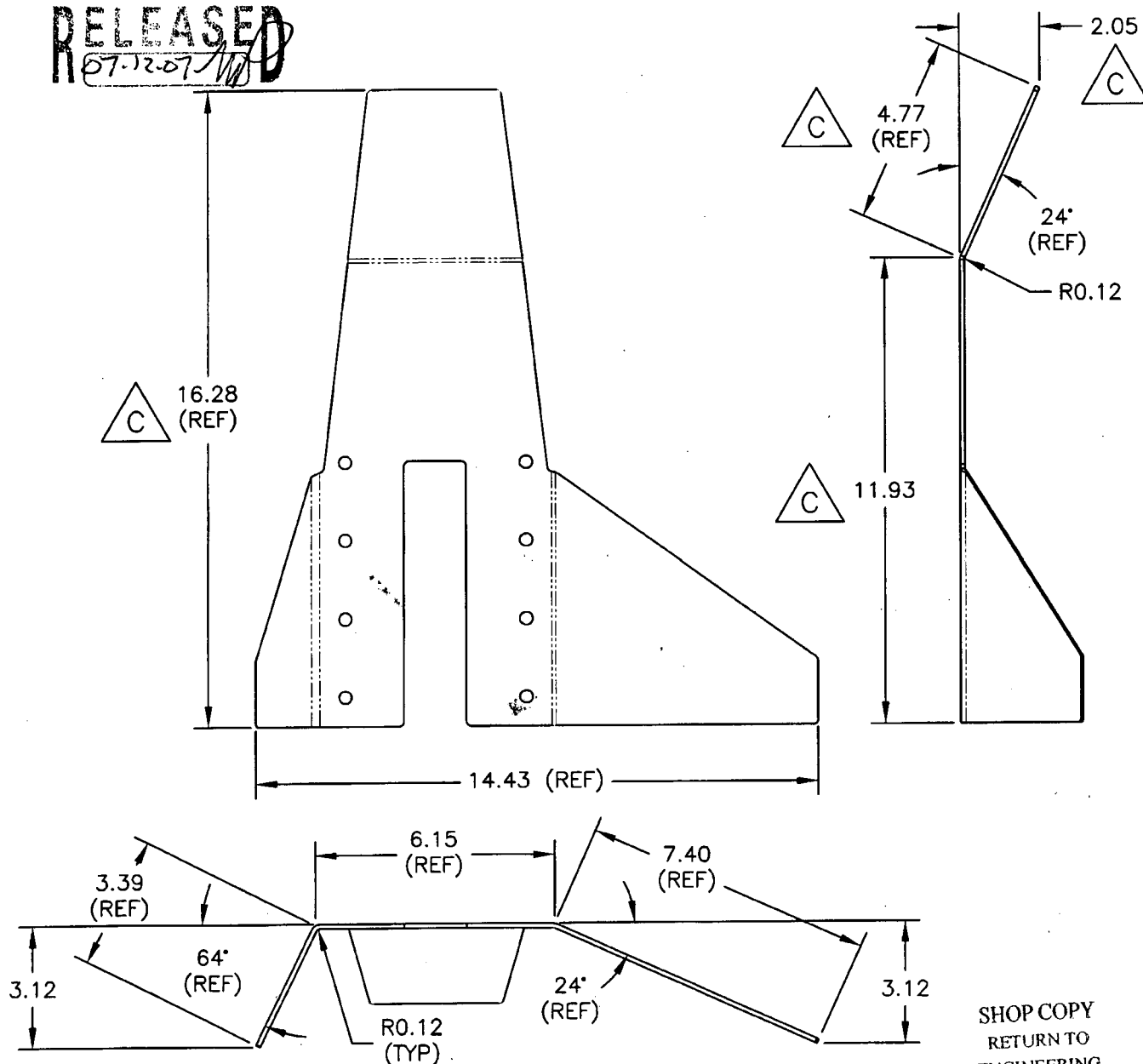
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**D3330-1 BEND DETAIL (SHOWN)**  
BEND D3330-2 (OPPOSITE)

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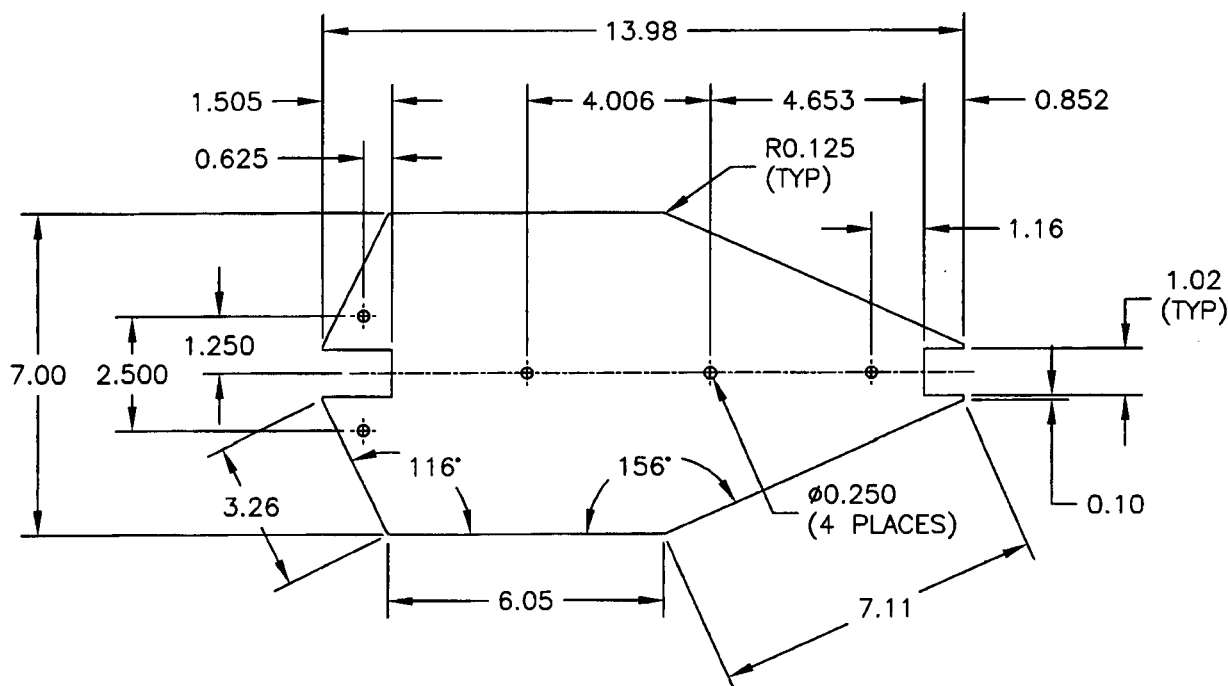
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### D3330-3 PLATE

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#### NOTES:

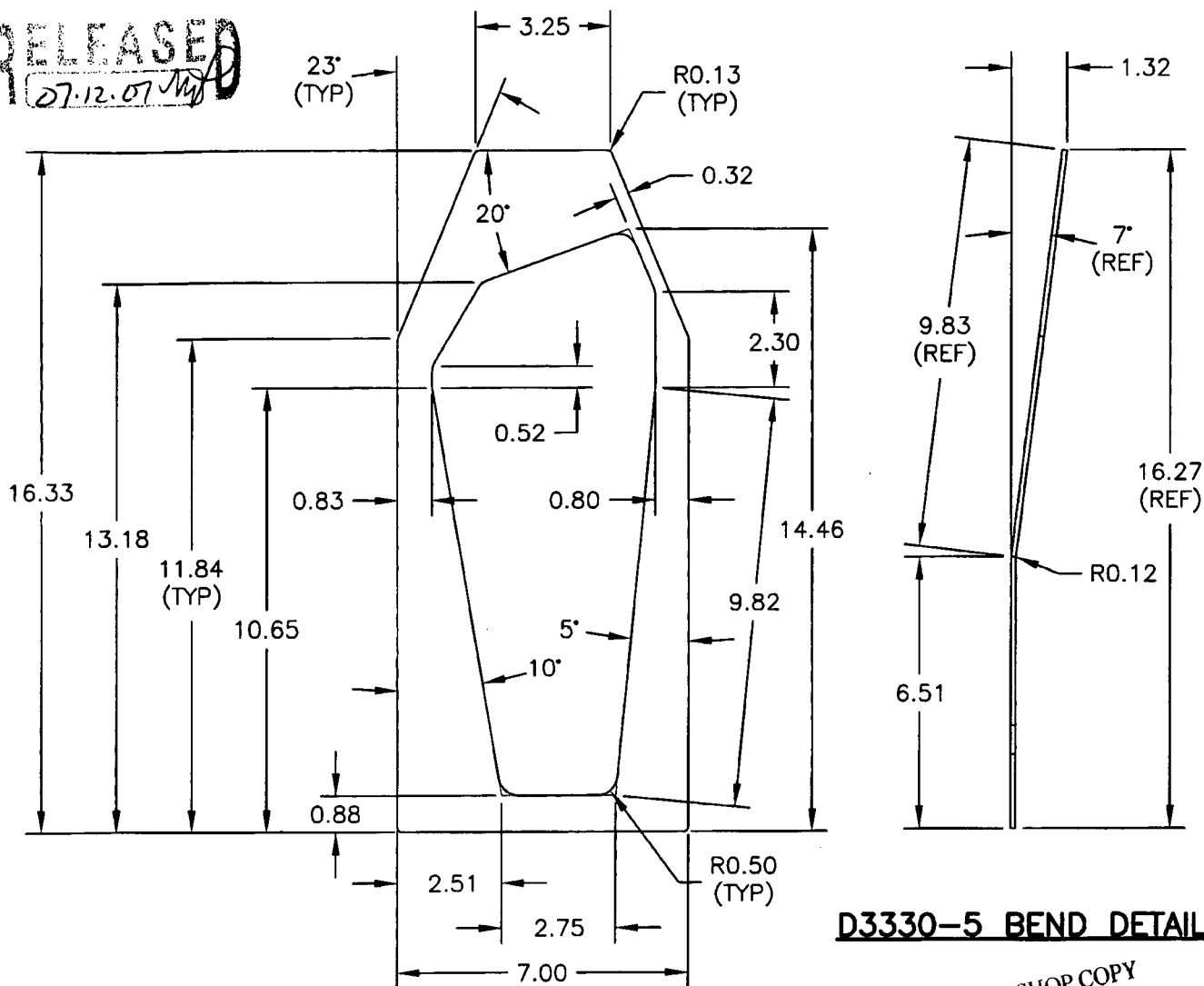
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED  
07.12.07 *My***FLAT PATTERN****D3330-5 BEND DETAIL**

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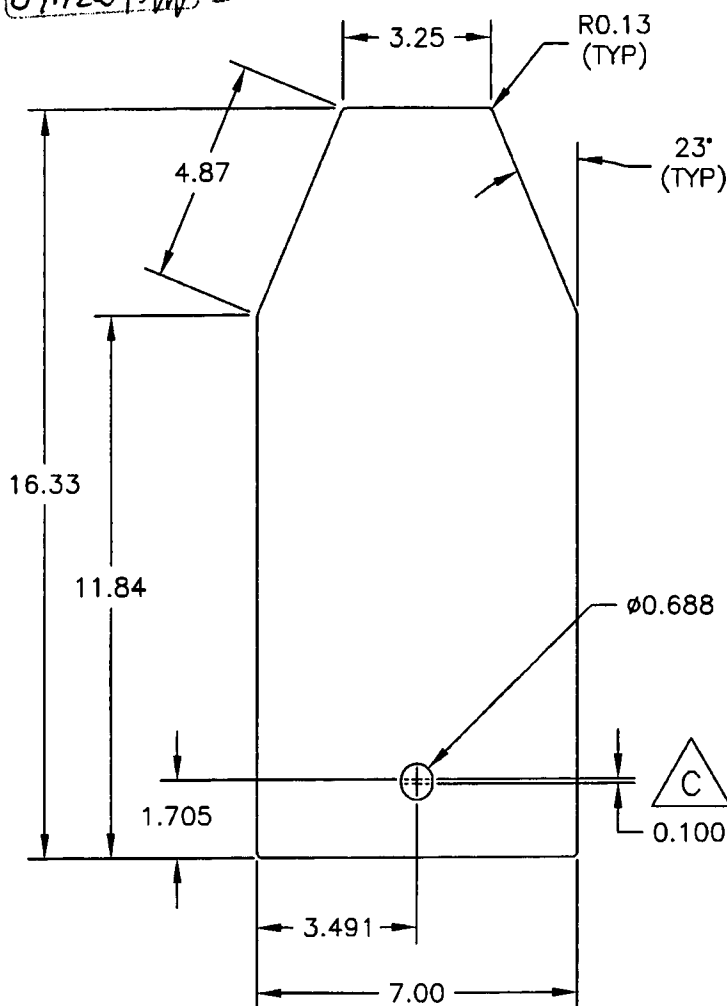
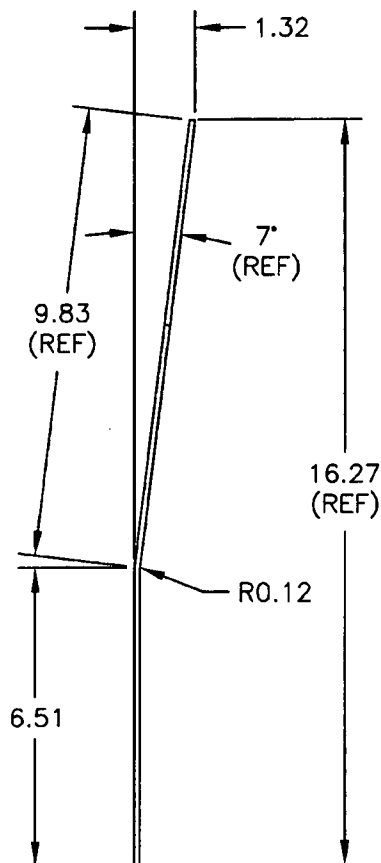
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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

RELEASED  
07.12.07 *[Signature]***FLAT PATTERN****D3330-7 BEND DETAIL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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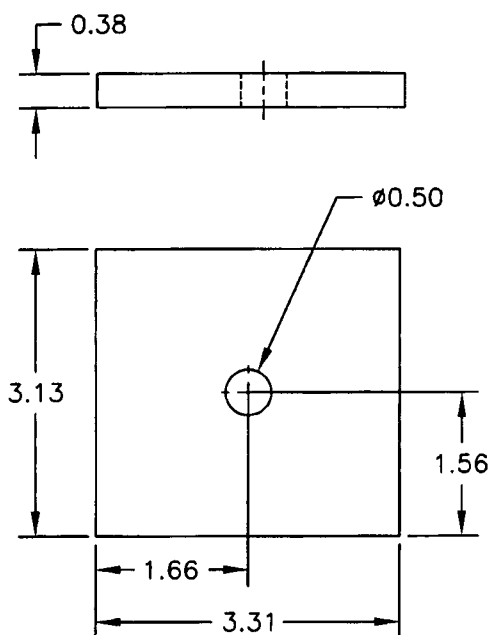
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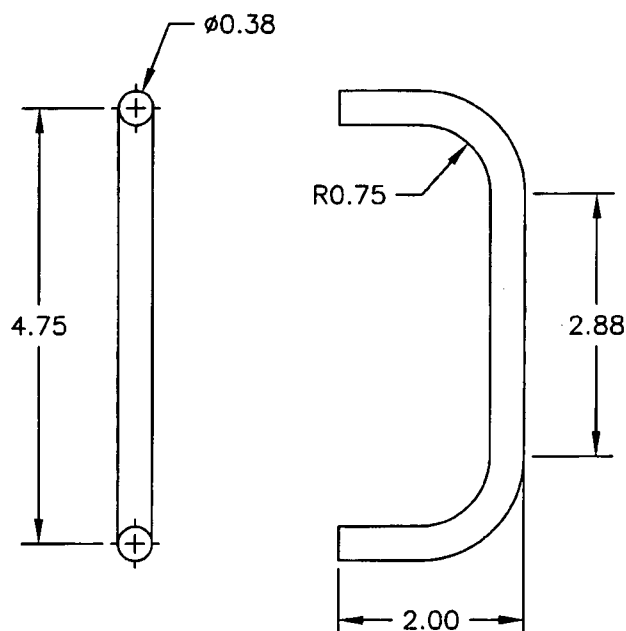


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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

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07.12.07



1 D3330-9 TOP PLATE



2 D3330-15 HANDLE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL SHOP COPY  
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

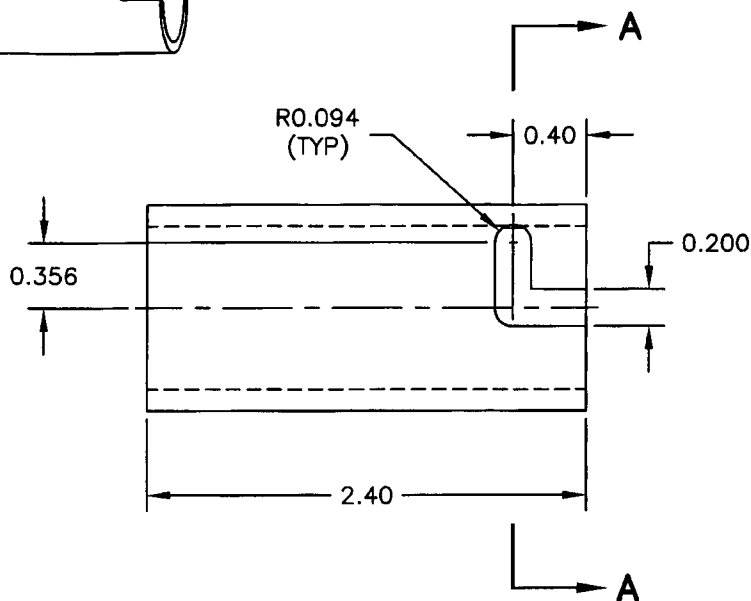
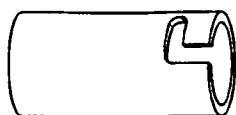
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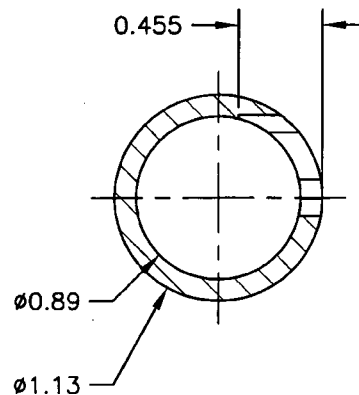
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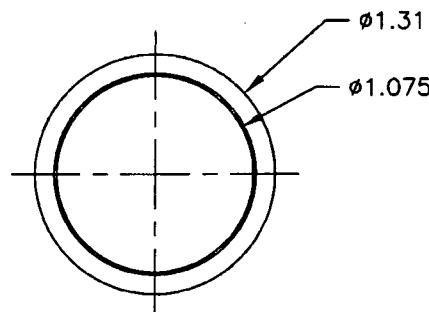
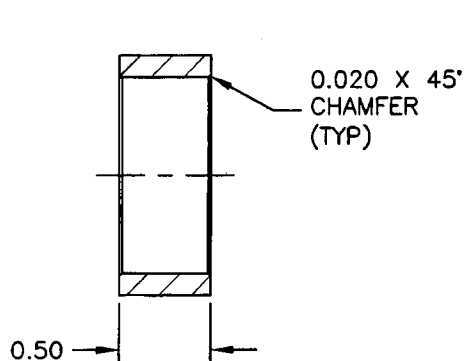


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07.12.07 *[Signature]*



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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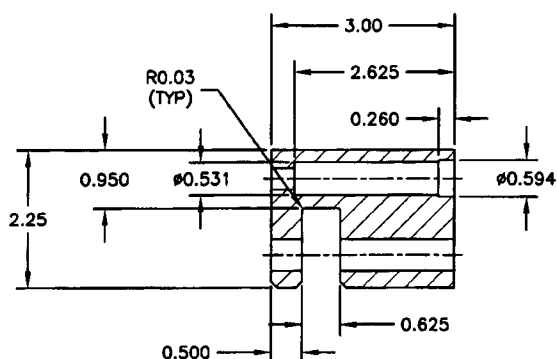
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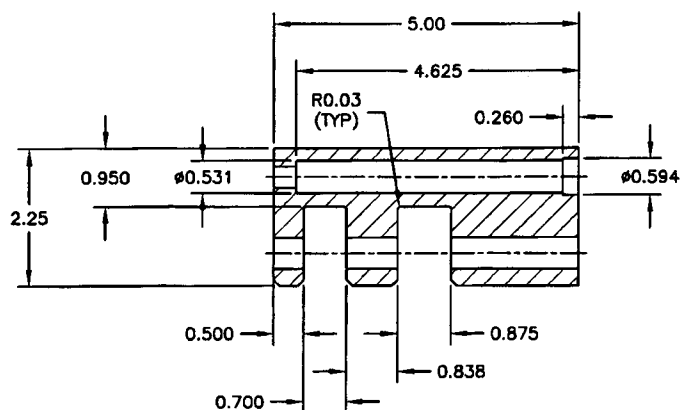
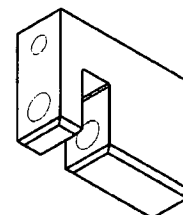
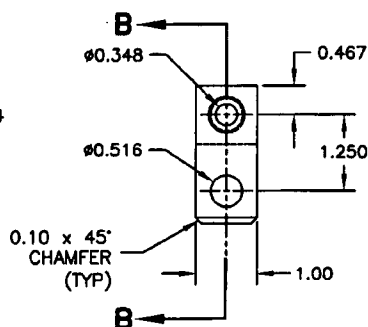
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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:3

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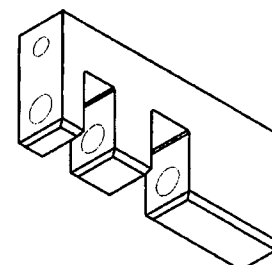
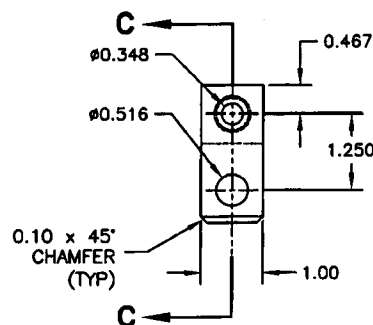
**SECTION B-B**

**D3330-13 SHORT PIN BRACKET**



**SECTION C-C**

**D3330-11 LONG PIN BRACKET**



**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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